

Work Order ID 64451

Monday, December 06, 2010 10:20:53 AM

Page 1

Item ID: D3662-1

Accept

Setup Start

Revisio ID:

Stop

Item Name: Crossbolt Spacer

Start Date: 12/6/2010 Start Qty: 10.00

Required Date: 12/13/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-12-06* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3662

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA720

SA 11/1/27

20 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 11/1/27

20 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

M.A 11/01/27

20 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 64451

Page 2

Monday, December 06, 2010 10:20:53 AM

Item ID: D3662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crossbolt Spacer

Start Date: 12/6/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

20 0 BEI/01/31

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/01/31

mf
11-01-31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:20:58 AM

Page 1

Work Order ID: 64451



Parent Item: D3662-1



Parent Item Name: Crossbolt Spacer

Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP ☐ A 08.02.04 ☐ Now turned on Cobra ☐ EC ☐

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6T0.625W.049 | | Purchased | No | | | 100 | f | 26.0000 | 0.31 | 3.263158 | | | |
| | | | | | | | | | | | | | |
| 6061-T6 RD Tube .625 x.049W | | | | | | | | | | | | | |



SN 111127

Location

Loc Qty

Loc Code

MAT014

26

107967

26

6.0 RT

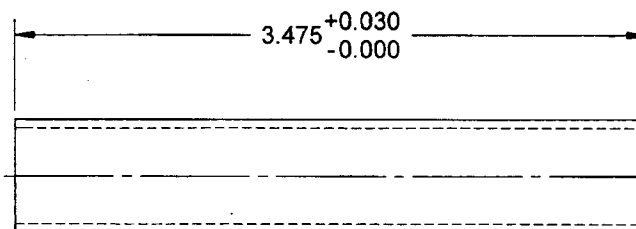
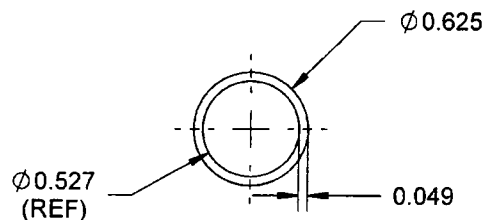
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

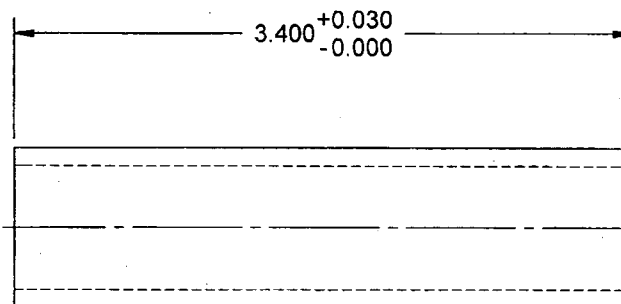
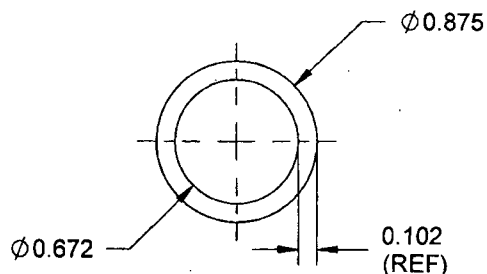
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries



D3662-1 CROSS BOLT SPACER



D3662-3 CROSS BOLT SPACER

NOTES:

1) MATERIAL:

- D3662-1 - ALUMINUM 6061-T6/T62
TUBING PER WW-T-700/6 OR AMS 4080/4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART MATERIAL SPEC. M6061T6T0.625W0.49)
- D3662-3 - ALUMINUM 6061-T6 (OR 6061-T651/T6510/T6511/T62)
ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART MATERIAL SPEC. M6061T6RX.XXX)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

**7) WEIGHT: D3662-1 - 0.03 LBS
D3662-3 - 0.08 LBS**

RELEASED
07.11.22

| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | PH | 07.04.20 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PA | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| DRAWN | PA | | |
| CHECKED | JP | DRAWING NO. | REV. A |
| MFG. APPR. | MP | D3662 | SHEET 1 OF 1 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | MP | CROSS BOLT SPACER | 1:1 |
| DATE | 07.04.20 | COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |